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5133425

D4634-145
Job Sheet 185366



006737

Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY: JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/30/18	0.00	0.00	Start Up Small Fab		Smb
110	Small Fab	1 pcs		11/30/18	0.00	1.47	Small Fab		Smb
120	QC	1 pcs		11/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/30/18	0.00	0.00	Packaging3		9-89 Smb
140	QC21-SA	1 Ea		11/30/18	0.00	0.00	QC21		21 9-89 DEC 04 2018

Part Op 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
Descriptions: Batch: m138715 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # m138958 Expiry Date April 19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138941
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-5	Aft, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	5054341
D4636-5	Bracket	1 Ea (1 ea)	90-Start up Operation	5004455
D4647-1	Doubler	1 Ea (1 ea)	90-Start up Operation	5113182
D4664-5	Spacer	6 Ea (6 ea)	90-Start up Operation	5113182
D4712-1	Bracket	1 Ea (1 ea)	90-Start up Operation	5121111
D4732-17	Label	1 Ea (1 ea)	90-Start up Operation	5020431
D4732-23	Label	1 Ea (1 ea)	90-Start up Operation	5121373
D4732-27	Label	1 Ea (1 ea)	90-Start up Operation	5020431
D5021-5	Foam, Center Panel, Aft	1 Ea (1 ea)	90-Start up Operation	5130156
MPNY-750S-9-C	Mounting Pad	9 pcs (9 ea)	90-Start up Operation	Am 130412-1
MS20426AD3-4	Rivet	4 Ea (4 ea)	90-Start up Operation	5093088-1
MS20426AD4-6	Rivet	2 Ea (2 ea)	90-Start up Operation	Am 1364442
MS21059L08	Nut	2 Ea (2 ea)	90-Start up Operation	5129976

CCR26455-3-03 X4

5099729

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

90-Start up Operation

D4634-5	1	1	0
D4636-5	1	39	0
D4647-1	1	9	0
D4664-5	6	21	0
D4712-1	1	17	0
D4732-17	1	12	0
D4732-23	1	12	0
D4732-27	1	5	0
D5021-5	1	1	0
MPNY-750S-9-C	9	126	0
MS20426AD3-4	4	4,602	0
MS20426AD4-6	2	1,909	0
MS21059L08	2	138	0

Part Specifications

Specifications could not be found.

Plex 10/25/18 12:56 PM Dart.lajeunesse.marie

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Container No: S133425



Part: D4634-145

Job No. 185366

Serial No, Batch: S133425

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					